



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1

Job Sheet 186627



Part No: D3278-1

Job Qty: 20 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 12/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/4/18	12/4/18	0.00	0.00	Start Up Machining-2		mm 18/11/18
100	Bandsaw	20 pcs	12/4/18	12/4/18	0.00	0.58	Bandsaw1		11/11/18
110	CNC Vertical Machining	20 pcs	12/4/18	12/4/18	0.06	6.27	HAAS 5 Axis		
120	Outsource	20 pcs	12/4/18	12/4/18			MEM001-VC		
125	Packaging	20 pcs	12/4/18	12/4/18	0.00	0.00	Packaging2		DEC 05 2018
130	QC	20 pcs	12/4/18	12/4/18	0.00	0.00	QC6		38
140	HandFinish	20 pcs	12/4/18	12/4/18	0.00	0.19	HandFinish1		DR 18/12/18
150	Powdercoat	20 pcs	12/4/18	12/4/18	0.00	0.15	Powdercoat1		BR 18-12-18
160	QC	20 pcs	12/4/18	12/4/18	0.00	0.00	QC3		DEC 10 2018
170	Packaging	20 pcs	12/4/18	12/4/18	0.00	0.00	Packaging3-1		DEC 10 2018
180	QC21-SA	20 Ea	12/4/18	12/4/18	0.00	0.00	QC21		9-89

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long

Descriptions: 110 - 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1

150 - START TIME: 1:10 OVEN TEMPERATURE: 350 FINISH TIME: 1:40

170 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	4.3400 ft (.217 ea)	90-Start up Operation	5115008 = 4.62 5110498 = 3.75

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.000	4	35	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359inches ± 0.005	0.364 0.354		
3	Support	0.609inches ± 0.010	0.619 0.599		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

4	Support	0.250inches $\pm$ 0.010	0.260 0.240
5	Support	1.480inches $\pm$ 0.005	1.485 1.475
6	Support	0.125inches $\pm$ 0.010	0.135 0.115
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115
8	Support	2.439inches $\pm$ 0.010	2.449 2.429
9	Support	1.980inches $\pm$ 0.010	1.990 1.970
10	Support	0.130inches $\pm$ 0.030	0.160 0.100
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257
12	Support	0.375inches $\pm$ 0.010	0.385 0.365
13	Support	0.875inches $\pm$ 0.010	0.885 0.865
14	Support	0.500inches $\pm$ 0.010	0.510 0.490
15	Support	0.400inches $\pm$ 0.010	0.410 0.390
16	Support	1.000inches $\pm$ 0.030	1.030 0.970
17	Support	1.720inches $\pm$ 0.010	1.730 1.710
18	Support	0.125inches $\pm$ 0.010	0.135 0.115
19	Support	0.125inches $\pm$ 0.010	0.135 0.115

Plex 11/19/18 10:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 832-5200 Email: sales@dartero.com www.dartaerospace.com Date: 11/23/18 Container No: S130828 Part: D3278-1 Job No: 186627 Serial No/Batch: S130828 Revision: Inspector: Exp Date: Instructions: Various STC's		CATEGORY <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="width: 50%; border: none;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	Lead hand / Supervisor Approval Verification															
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				QC / QA Coordinator Approval																	
OTHER : _____																					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041823**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041823
PO Date: 11/23/18
Due Date: 12/12/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186627	D3278-1			Support : Various STC's	Firmed -		12/12/18	40 pcs	0 pcs	40 pcs	\$25.05/pcs	\$1,002.00
2	186626	D3278-2			Support : Various STC's	Firmed -		12/12/18	40 pcs	0 pcs	40 pcs	\$25.05/pcs	\$1,002.00
Grand Total:												\$2,004.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/23/18 11:31 AM dart.Lussier.Patrick

DAS
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**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24333
Shipment Date: 04-Dec-2018
Ship Via: Pick up at METEC
Order Number: 3230
Order Date: 11/23/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041823 ✓
Terms: Net 60 Days

----- Quantity -----							Job	
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	40	40 ✓	0	0	EA	DART-D3278-1P Support, as per drawing D3278	C	3230-01
2	40	40 ✓	0	0	EA	DART-D3278-2P Support, as per drawing D3278-2	C	3230-02

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The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
40 ✓	D3278-1 ✓	Support	C	S130858	Unpainted	✓ 41823
40 ✓	D3278-2 ✓	Support	C	S130858	Unpainted	✓ 41823

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MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, December 4, 2018

1914-1915

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